

Work Order ID 155128

Monday, January 09, 2017 10:52:42 AM

155128

Page 1

ASAP

Item ID: D4972-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Plate Assembly

Start Date: 1/9/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/20/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: mf Date: _____ Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4972	A
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DAS
46
9-89

17/01/09

100

0.02

100

Waterjet

Memo

0.03

FLOW CNC Waterjet

1-Cut D4972-1 as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

DAS
46
9-89

17/01/09

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Monday, January 09, 2017 10:52:42 AM

155128

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Item ID: D4972-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Side Plate Assembly
 Start Date: 1/9/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/20/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.03				(x4)	✓	2017/01/17	BEB.
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.01				11	φ	17-01-18.	333
Quality Control									
170	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
170									
Powdercoat	Small Fab M 129777	0.01				4	φ	17-01-18	343
Powder Coating	Memo								

START TIME: 7:40
 OVEN TEMPERATURE: 300°
 FINISH TIME: 8:10

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Revision ID: Stop ***NS2***
Item Name: Side Plate Assembly
Start Date: 1/9/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/20/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				4x			17/01/18 DAS 36 9-89
190 *190* Small Fab Small Fab	ASSEMBLE AS PER DWG Memo	0.00 0.02				4x			17/01/18 DAS 36 9-89
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				9			DAS 38 9-89 JAN 18 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Item ID: D4972-041

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Plate Assembly

Start Date: 1/9/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/20/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: Stk 21

0.00

210

Packaging

Memo

0.01

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.07

Quality Control

DAS
21
9-89

JAN 19 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Picklist Print

Monday, January 09, 2017 10:52:42 AM

Page 1

Work Order ID: 155128

155128

Parent Item: D4972-041

D4972-041

Parent Item Name: Side Plate Assembly

Start Date: 1/9/2017

Required Date: 1/20/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.11.19 NEW ISSUE DD VERF:JLM IPP
REV:B 14.04.01 AS RE DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

sf

203.0100

2.484211

**

DAS
46
9-89

17/01/09

M6061T6S 040

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

203.01

m135612

30

m135632

45.01

m135724

128

1.5

MS20426AD3-3

Purchased

No

Each

5,195.000

16

**

17/01/18

DAS
36
9-89

MS20426AD3-3

RIVET

Location

Loc Qty

Loc Code

fg108

440

M134946

200

M135354

120

M135894

120

GA

1914

M135274

1914

ST312

2841

M135274

2841

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

Monday, January 09, 2017 10:52:42 AM

Page 2

Work Order ID: 155128

155128

Parent Item: D4972-041

D4972-041

Parent Item Name: Side Plate Assembly

Start Date: 1/9/2017

Required Date: 1/20/2017

Start Qty: 4.00

Required Qty: 4.00

MS21059L3

Purchased

No

Each

179.0000

8

MS21059L3

**

17/01/18 DAS 36 789

Nut Plate

Location

Loc Qty

Loc Code

GA	12
M135603	12
ST301	167
M135774	37
M136047	65
M136450	65

8

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

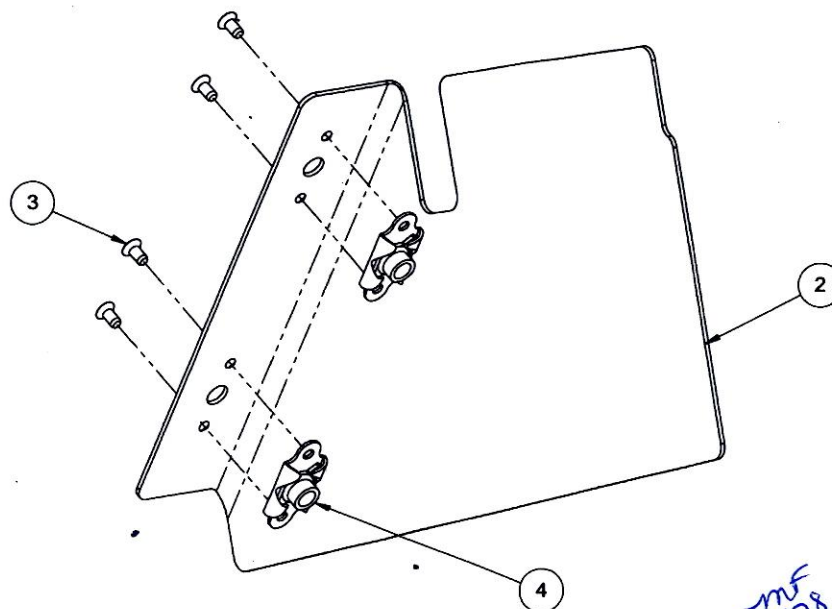


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Work Order update only ☐

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		OTHER : ☐							

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4972-041	SIDE PLATE ASSY
2	1	D4972-1	SIDE PLATE
3	4	MS20426AD3-3	RIVET (NASM20426AD3-3)
4	2	MS21059L3	NUT PLATE (NASM21059L3)



D4972-041 SIDE PLATE ASSY

mf
155198

RELEASED
2014-03-31
md

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 7) WEIGHT: 0.09 LBS

A		NEW ISSUE		DB	14.01.20
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE LTD			
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA			
CHECKED	DC	DRAWING NO.	REV. A		
MFG. APPR.	DD	SIDE PLATE ASSY		SHEET 1 OF 2	
APPROVED	HS	TITLE	SCALE		
DE APPR.	DS	D4972	NTS		
DATE		14.01.20			
COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD					

DQA: _____ Date: _____

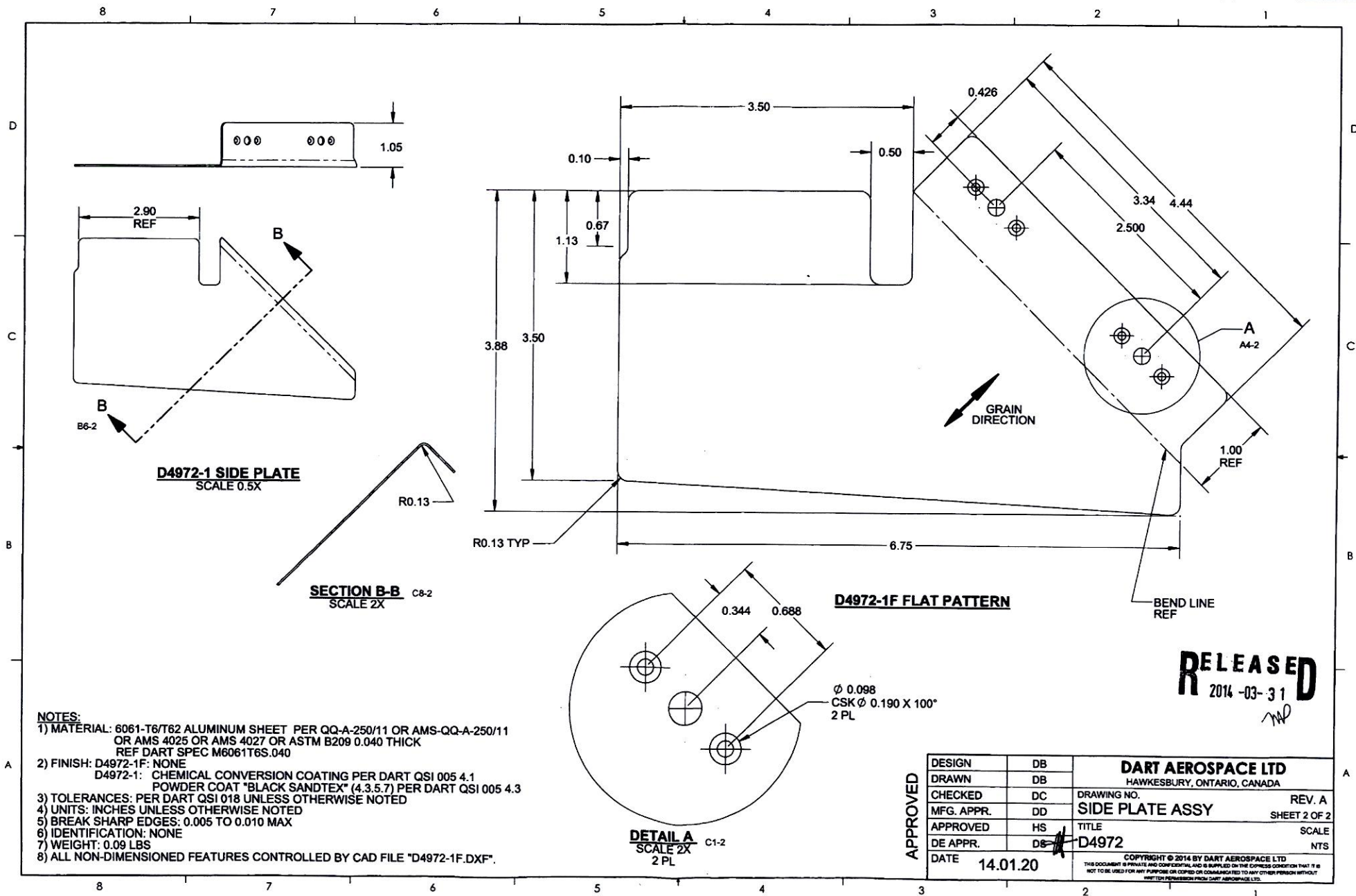


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